Monday, May 30, 2011 11:26:02 AM													
Revision ID: Item Name: Clip												-	Page 1
Revision ID: Item Name: Clip	Item ID:	D3546-1		A	ccept					Setup	Start		
Start Date:								#)		·			
Required Date: 6/10/2011 Req'd Qty: 12.00 Reference: Approvals: Process Plan: Date: SPC (Y/N): Date: Stop QC: Date: SPC (Y/N): Date: Stop Work Center ID Description Draw Nbr Revision Nbr D3546 Rev A Stup/ BLOW WATER JET Waterjet Memo O.00 FLOW WATER JET Waterjet Memo QC2- Inspect parts off machine FAI/FAIB QC Memo O.00 Run Dota Run Start Julia Star	Item Name:	Clip									Stop		
Reference: Approvals: Process Plan: MF Date: 1-05-30 Tooling: Date: SPC (Y/N): Date: Stop Work Center ID Description Run Hours Code Qty Qty Number Stamp Draw Nbr Revision Nbr Date: SPC (Y/N): Date: SPC (Y/N): Date: Stop Work Center ID Description Run Hours Code Qty Qty Number Stamp Draw Nbr Revision Nbr Date: SPC (Y/N): Date: Stop Work Center ID Tool # Plan Accept Reject Reject Reject Number Stamp Run Hours Code Qty Qty Number Stamp Nor Nor Nor Number Stamp Nor Nor Number Stamp Nor Nor Numbe	Start Date:	5/30/2011	Start Qty: 12.00			Cust Item I	D:						
Approvals: Process Plan: MF Date: -05-30 Tooling: Date: Stop Work Center ID Description Set Up/ Run Hours Tool ID Tool # Plan Accept Reject Reject Insp. Code Qty Qty Number Stamp Draw Nbr Revision Nbr D3546 Rev A Revision Nbr Revision Nbr D3546 Rev A Revision Nbr Revision Nbr Revision Nbr D3546 Rev A Revision Nbr Revision Nb	Required Date:	6/10/2011	Req'd Qty: 12.00			Customer:							
QC: Date: SPC (Y/N): Date: Stop Work Center ID Description Set Up/ Run Hours Date: SPC (Y/N): Date: Stop Work Center ID Description Run Hours Draw Nbr Revision Nbr D3546 Rev A 100 FLOW WATER JET Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dag D3546 Dwg Rev: A 2-Deburr if necessary QC Memo 0.00 Run Hours Stop Waterjet Insp. Reject Reject Reject Insp. Reject R	Reference:		·	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,									IST 1181 100.
QC: Date: SPC (Y/N): Date: Sequence ID/ Operation	Approvals:	Process Plan	: Mr	Date: []-05-30	Tooling:	Da	ate:			Run			
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D3546 Rev A			•			Tool ID	Tool #						Insp. Stamp
100 Waterjet Memo 1Cut as per Dwg D3546 Dwg Rev: Prog Rev: A 2-Deburr if necessary QC Memo 0.00 **Bit- 6-1 **Deburr if necessary 0.00 **Bit- 6-1	Draw Nbr	Revis	sion Nbr										
FLOW WATER JET Waterjet Memo 1-Cut as per Dwg D3546 Dwg Rev: Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 RB11-6-1 O00 RB11-6-1 O00 RB11-6-1	D3546	Rev A	4										
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Waterjet Memo 1-Cut as per Dwg D3546 Dwg Rev: Prog Rev: 2-Deburr if necessary 10 QC2- Inspect parts off machine FAI/FAIB QC Memo 0.00 RB1- G-1			FLOW WATER JET						- Ru	61			
Prog Rev:			Memo		0.00				- NEW 11.	- V-1			· · · · · · · · · · · · · · · · · · ·
Memo 0.00		et	Prog Rev:_	A								(3)	
QC Memo 0.00			QC2- Inspect parts off n	nachine FAI/FAIB	0.00								
	QC		Мето		0.00				BI	<u>-</u> (6-1	4		

120

Quality Control

Memo

QC8- Inspect parts - second check

0.00 SW.6102

(412)

W/O:			N	ORK ORDER CHA	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Ca	tegory:	NCI	R: Yes I	Vo DQ	A:	_ Date: _	
		esolution:		-						
NCR:		V	VORK OR	DER NON-CONFO	RMANCE	(NCR)		, Tg*	
DATE	STEP	Description of NC		Corrective Action	Section B	0: 0	Verification		Approval	Approval
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Work Order ID 701	เวบ
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Monday, May 30, 2011 11:26:02 AM

Page 2

Item ID:

D3546-1

Accept

Setup Start

Stop

Revision ID:

Item Name:

Required Date: 6/10/2011

Clip

5/30/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

QC:

Process Plan:

Date:

SPC (Y/N):

Tooling:

Date:

Tool # Plan

Code

Date:

Start

Reject

Qty

Stop

Reject

Run



Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Set Up/ **Run Hours**

Date:

0.00

0.00

5B 11/06/07

Form as per Dwg D3546

Memo

Memo

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Sulpho 7

Accept

Qty

150

Packaging

Memo

Identify as per dwg & Stock Location:

0.00

Packaging

0.00

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DG	A:	Date:	······
	R	esolution:	Dispositio	n:	_ QA: N/C (closed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NC	R)	-		
		Description of NC			Section B Verificat			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector

[→] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 70150

Monday, May 30, 2011 11:26:02 AM



Page 3

Item ID:

D3546-1

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Start Date:

Clip

5/30/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Date:

Customer:

Reference:

A	DI	ro	va	IS:

Process Plan:

Operation

Date: Date:

Tooling:

Date: _

Start Run

QC:

Required Date: 6/10/2011

Sequence ID/ Work Center ID

160

Description QC21- Final Inspection - Work Order Release Set Up/ Run Hours

SPC (Y/N):

Tool ID

Tool# Plan Code

Reject Accept Qty

Qty

Reject Number

Insp.

Memo

0.00

0.00

Stamp

Quality Control

mt 016-08

	<u> </u>									
W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*								
Part No	•	PAR #:	Fault Cat	egory:	NCR: `	Yes N	o DQ	A:	Date: _	
		esolution:								
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (I	NCR)				
- 4		Description of NC		Corrective Action Section			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		ion C	Chief Eng	QC Inspector
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Picklist Print

Monday, May 30, 2011 11:25:59 AM

Work Order ID: 70150

Parent Item:

D3546-1

Parent Item Name: Clip



Start Date: 5/30/2011

Required Date: 6/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-09-27 JLM

remove finish DD 10.03.29 verified by:EC

JPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA	INDICATE OF THE LAND	Purchased	No			100	sf	180.0000	0.04	0.505263			
										B11	1-6-1		

304/316 .050 Sheet

Location	Loc Qty	Loc Code	
MAT020	180		
112178	4		112178
113062	18		
116135	20.5		
116604	1.5		
116979	69		
117653	67		



W/O:			V	ORK ORDER CHANG	ES				,	
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-		
Part No		PAR #:	Fault Ca	tegory:	NCR	Yes I	do DQ	4 :	Date:	
	R	esolution:	Disposit	ion:	_ QA:	WC Clo	sed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Cian 8	Verific		Approval	Approval
DAIL	O.E.	Section A	Initial Chief Eng	Action Description Chief Eng	•	Sign & Date	Section	on C .	Chief Eng	QC Inspector
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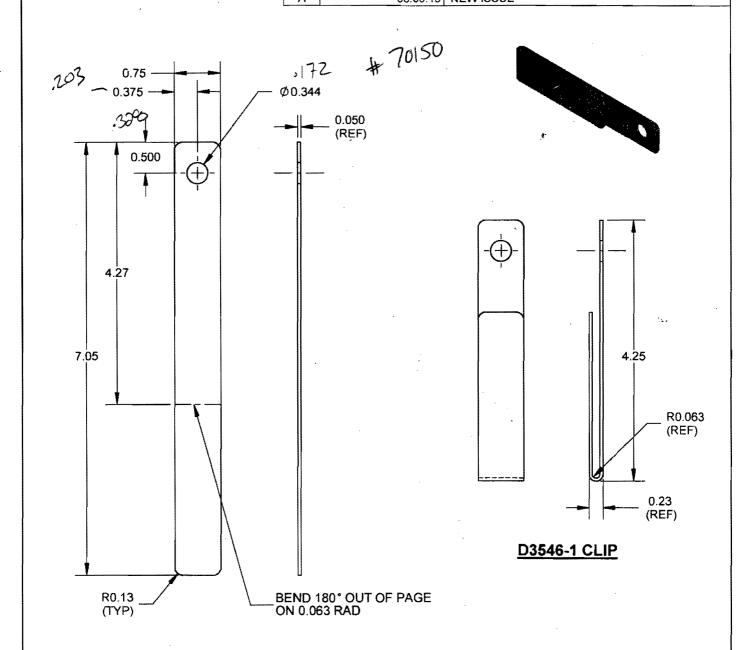
DART AEROSPACE LTD	Work Order:	70150
Description: Clip	Part Number:	D3546-1
Inspection Dwg: D3546 Rev: A		Page 1 of 1

	FIRS	ST ARTICLE	INSPEC	TION CH	ECKLIST		
		X First A	rticle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
7.05	+/-0.030	7.048	*		V BOZ		
0.500	+/-0.010	,500	ش		ν		
0.75	+/-0.030		×		ν		
0.375	+/-0.010	200	<u>}</u>		٧		
0.050	+/-0.010	-40	77		γ		
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			-10-				
Measured by:	Œ	Audited by	10		Prototype Appro	oval:	N/A
Date:	11-6-1	Date	: 11/06/	[2]		Date:	N/A
Rev Date	Change			-	Revis	sed by	Approved

Rev	Date	Change	Revised by	Approved
Α	07.04.02	New Issue	KJ/JLM X	ad
			7.71	7//

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCE	IANGE By C			ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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							,					
			•									
Part No:		PAR #:	PAR #: Fault Category:			NCR: Yes No DQA:				Date:		
	R	esolution:	Disposit	ion:	QA: N/C Closed:				Date:			
NCR:		WC	ORK OR	DER NON-CONFORMA	NCE (NO	CR)		er.				
DATE	STEP	Description of NC Section A	Corrective Action Section E			VA		ation	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng	Sig Da		Section C		Chief Eng	QC Inspector		
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DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	(ED	APPROVED	DRAWING NO.	REV. A			
(4		D3546	SHEET 1 OF 1			
DATE			TITLE	SCALE			
06.09.15			CLIP	1:1			
 REV		DATE		DESCRIPTION			
Α		06 09 15	NEW ISSUE				



D3546-1F FLAT PATTERN

- NOTES:
 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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						,			
Part No:		PAR #:	Fault Ca	tegory:	NCR: Yes	s No DG	A:	Date:	
	R	esolution: Disposition:			QA: N/C	Closed: _	Date:		
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NC	R)		-	
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Verification		1 Approval	Approval
DAIL			Initial Chief Eng	Action Description Chief Eng	Sigr		tion C	Chief Eng	QC Inspector
									
		,							